

Date: Wednesday, 22/04/2009 12:53:21 PM
 User: Melanie Fauteux

Process Sheet

SHIP 24/04

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARSHOE
 Job Number : 47374
 Estimate Number : 12730
 P.O. Number :
 This Issue : 22/04/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D353537
 First Issue : / / Type : SMALL / MED FAB Drawing Number : D3535 REV B
 Previous Run : Project Number : N/A
 Material :
 Due Date : 24/04/2009 Qty: 10 Um: Each
 Written By :
 Checked & Approved By : MF 09-04-22
 Comment : Est Rev:A New Issue 07-02-15 JLM
 Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S20GA 304/316 .040 Sheet



Comment: Qty.: 0.8353 sf(s)/Unit Total : 8.3528 sf(s)
 304/316 .040 Sheet
 (M304S20GA)
 Batch: 110076 B9-4-22

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3535
 Dwg Rev: B
 Prog Rev: B

B9-4-22

(10)

2-Deburr if necessary B9-4-22

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B9-4-22

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

2094.22 (10)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
 1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.
 2- Identify as D3535-37

EX 22/04/23

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 22/04/2009 12:53:21 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 47374

Part Number: D353537

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

507/04/23 (x10)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 109648

START TIME:

11:20

OVEN TEMPERATURE:

320°

FINISH TIME:

11:30

BR 09-04-23

(10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/04/23

(10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Finishing Dept

SS 09/04/23 (x10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/24

18

Job Completion



MF 09-04-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47374
Description: WEAR SHOE		Part Number: D3535-37
Inspection Dwg: D3535-37 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
300X.300	+/- .010	302X302	*			
1.885	+/- .010	1.888	*			
2.060	+/- .010	2.000	*			
4.750	+/- .010	4.750	*			
9.500	+/- .010	9.500	*			
14.250	+/- .010	14.250	*			
17.750	+/- .010	17.750	*			
22.500	+/- .010	22.500	*			
27.250	+/- .010	27.250	*			
30.750	+/- .010	30.750	*			
6.00	+/- .030	6.00	*			
8.00	+/- .030	8.00	*			
16.00	+/- .030	16.00	*			
21.00	+/- .030	21.00	*			
φ .188	+ .005 - .001	.190	*			
.040	+/- .010	.039	*			

Measured by: JB	Audited by: [Signature]	Prototype Approval: [Signature]
Date: 9-4-22	Date: 09-01-22	Date: 1/17

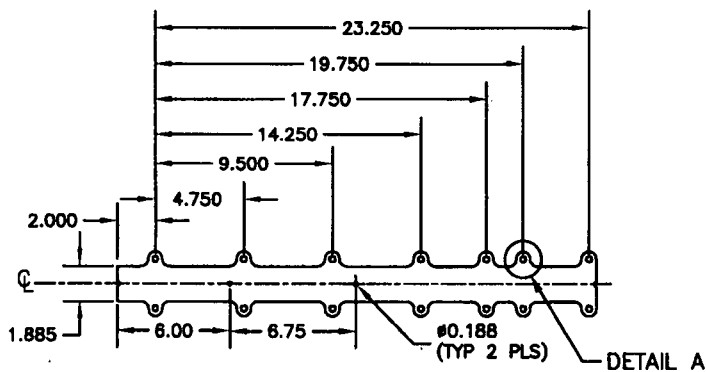
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART

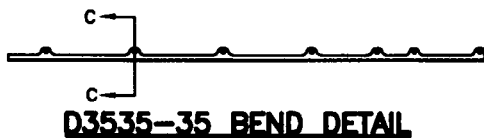
RELEASED

07.04.17

DESIGN	CB	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 5 OF 7
		SCALE	1:10	

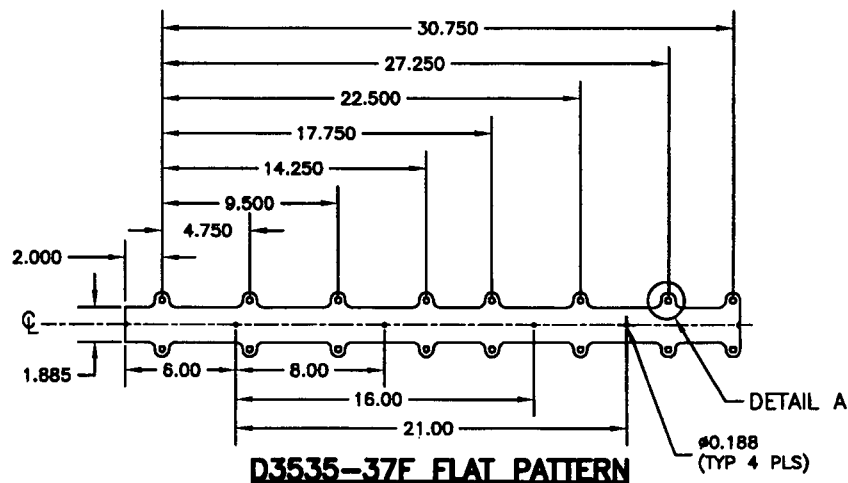


D3535-35F FLAT PATTERN

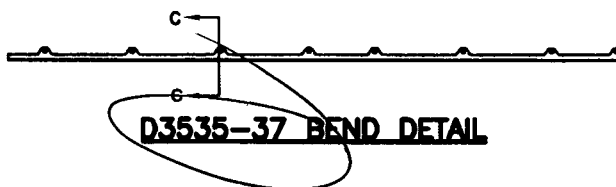


D3535-35 BEND DETAIL

47374



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
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